

Work Order ID 148071

June 23, 2016 11:20:54 AM

148071

Page 1

Item ID: D3566-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gasket Center Aft
Start Date: 6/23/2016 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 6/28/2016 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: SA Date: 6/23/16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3566	Rev C								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.20							
FLOW CNC Waterjet	1-Cut as per Dwg D3566 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.08							
Quality Control									

DAS
38
9-89
JUN 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 6/23/2016 **Start Qty:** 24.00

24

Cust Item ID:

Required Date: 6/28/2016 **Req'd Qty:** 24.00

24

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location:_____

0.00

130

Packaging

Memo

0.04

Packaging

LOCATION : FP001

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.40

Quality Control

27

JUN 28 2011

16/6/29

dm 16/06/28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐											

Picklist Print

June 23, 2016 11:21:00 AM

Page 1

Work Order ID: 148071

148071

Parent Item: D3566-5

D3566-5

Parent Item Name: Gasket Center Aft

Start Date: 6/23/2016

Required Date: 6/28/2016

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B Added Drain Holes 07-07-09 JLM
IPP Rev:C As per Rev C 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	270.5000	1.06	28.26667			

MNEO60S 063
NEOPRENE SHEET 0.063

dx 16/06/24

Location

Loc Qty

Loc Code

MAT052

270.5

M133744

70.5

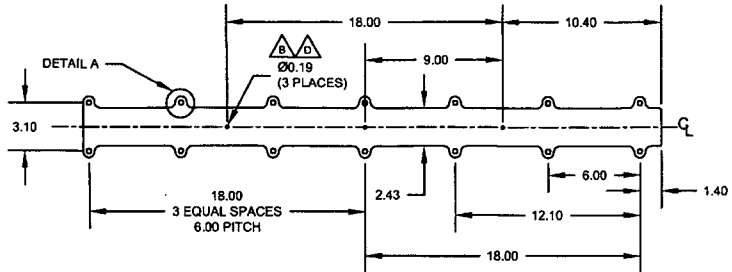
M134972

200

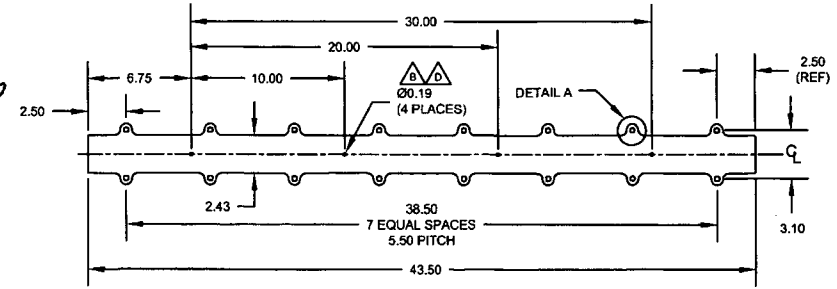
30

8 7 6 5 4 3 2 1

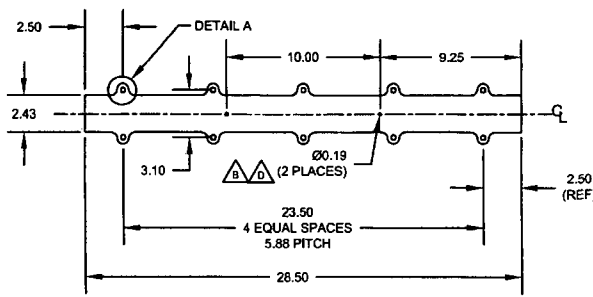
148071
SH
6/23/16



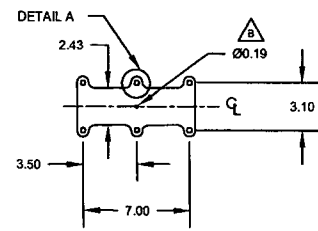
D3566-1 GASKET



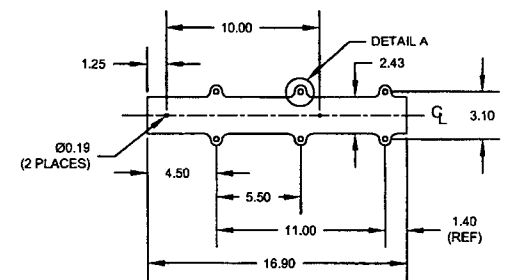
D3566-5 GASKET



D3566-7 GASKET

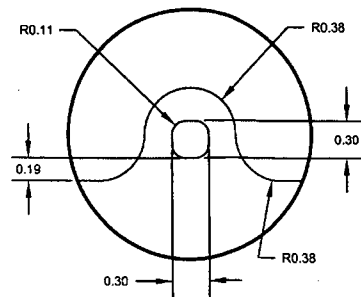


D3566-13 GASKET



D3566-15 GASKET

RELEASED
07.08.04



DETAIL A
SCALE 1:1

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: SEE TABLE IN ZONE A3
 - 8) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

D3566-1	0.29 lbs
D3566-5	0.36 lbs
D3566-7	0.24 lbs
D3566-13	0.07 lbs
D3566-15	0.15 lbs

C	UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); A8: UPDATE NOTES; A8, B2: ADD D3566-15; A5: INCREASE SIZE OF DETAIL A;		CB	07.08.21
	ADD DRAIN HOLES		PH	07.04.17
B	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD		
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA		
CHECKED	PH	DRAWING NO.	REV. C	
MFG. APPR.	PH	D3566	SHEET 1 OF 1	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	GASKET	1:8	
DATE	07.08.21		COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	148071
Description: Gasket		Part Number:	D3566-5
Inspection Dwg: D3566 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
38.50	+/-0.030	38.50	✓		V: 0.02	
43.50	+/-0.030	43.50	✓		Tape	
5.50 Pitch	+/-0.030	5.50	✓			
2.50	+/-0.030	2.50	✓			
2.43	+/-0.030	2.43	✓			
3.10	+/-0.030	3.10	✓			
2.50	+/-0.030	2.50	✓			
0.30	+/-0.030	.30	✓			
0.30	+/-0.030	.30	✓			
0.063	+/-0.010	.058	✓			
6.75	+/-0.030	6.75	✓			
10.00	+/-0.030	10.00	✓			
20.00	+/-0.030	20.00	✓			
30.00	+/-0.030	30.00	✓			
Ø0.19	+/-0.030	Ø.19	✓			

Measured by:	pc	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	16/06/24	Date:	JUN 27 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	07.09.06	Ø0.188 dimension removed	KJ/JLM	
D	08.01.16	Dwg Rev updated	KJ/EC/DD	DD